Work Orde November-02-11	er ID 75967 10:43:11 AM	.'	*759	967*						Page 1
Revision ID:	D3255-042 Access Panel Assembly	, ,	Accept	*N900	040	100)* S	Setup Star Stop	1.7	S1* S2*
	02/11/2011 Start Qty: 4.00/ 16/11/2011 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				10	. 12
Approvals:	Process Plan: M.C.J	Date: 11)11)) Tooling:	D:	ate:		R	Run Star	1/1	R1*
٠.	QC:	Date:		Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3255	Rev B									
*100 *100* Large Fab Large Fab	Large Fab Memo 1-Weld as Batch:	per Dwg D3255 ***purg 4/15 778 2-Grind	0.00 0.00 e weld***A/R SS ROD Welds Flush			-	L	y 11/1.	ı ļos	
*110 *110* QC Quality Control	QC10- Inspect visual p	er QS1004- ground welds	0.00	ululo		-				
120 *17	QC5- Inspect part com	pleteness to step on W/O	0.00	اساري	X.	-	(42)	 17		

Part No:P	AR #:	Fault Category:	NCR: Yes No	DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed	:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE STEP		Description of NC		Corrective Action Section B	Varification			
	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto
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Batch: M 1164

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W/O:		WORK ORDER CHANGES					
DATE STEP		PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:	_	•	WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC		Corrective Action Section B	<u> </u>	Manifia ati a		
	Section A		Initial Action Description Sign & Chief Eng Date			Verification Section C	Approval Chief Eng	Approval QC Inspector

Work Ord November-02-1				*759	967*			Page 3
Item ID: Revision ID: Item Name:	D3255-042 Access Panel	Assembly		Accept	*N900040	0100 *	Setup Star	1/1/2 1
Start Date: Required Date: Reference:	02/11/2011 : 16/11/2011	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:			
Approvals:		an:			Date:		Run Start	"INH I"
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Hours 0.00	Tool ID Tool	# Plan According Code Qty	Qty	Reject Insp. Number Stamp
170 *170* Packaging Packaging		Identify as per dwg & Sto	PPN7589	0.00			Caff	1/22 (2)
180 *1 A A * QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00			V	1 M /22 A)

MF (1-11-28

	erospac	e Ltd						•
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Picklist Print

November-02-11 10:43:16 AM

Work Order ID: 75967

75967

Parent Item: D3255-042 *D3255-042*

Parent Item Name: Access Panel Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:C

Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Location Loc Oty Loc Code WA 2 2		Date Issued	Qty Issued	Total Qty	Qty per Kit	Qty on Hand	Unit of Measure	Route Seq ID	Last Location	Primary Location	Bin Item	Mfg/ Purch	Replacement Item ID	Component Item ID/ Item Name
Location Loc Oty Loc Code WA 2				4 1	1	2.0000	Each	100			No	Manufactured		D3255-2
WA 2 71676 2 71676 2 *\infty \text{3255-5} *\infty \text{3255-5} *\infty \text{3255-5} Manufactured No 100 Each 1.0000 1 4 *\infty \text{SB W \(\alpha \) 150 Each 6.0000 1 4 *\infty \text{3255-3} *\i	<u> </u>	De	11/11	SY	**									
71676 2 **D3255-5* Manufactured No 100 Each 1.0000 1 ** ** ** ** ** ** ** ** **						Loc Code	<u>Oty</u>	Loc (Location				
Manufactured No 100 Each 1.0000 1			-	(2.1)	_				71676					
D3255-5 Gasket ** Spulation GA 1 6 75 0 8 3 72118 ** Spulation GA 1 1 6 75 0 8 3 ** D3255-3 ** Manufactured No 150 Each 6.0000 1 4 11 11 10 8 ** D3255-3* Cap			-	4	1	1.0000		100	71070		No	Manufactured		D3255-5
GA 1 675083	_ 		ulales	Sp	**									
*D3255-3 Manufactured No 150 Each 6.0000 I 4				<u></u>	33 2	Loc Code 750	Oty 1 B	<u>Loc (</u>		GA				
D3255-3			_	4 .	ı —	6 0000	I Fach	150	72118		No	Manufactured		03255-3
		08	11/11	Sy	**	0.0000	Such	150			,,,	ivianuractured		*D3255-3*
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>			•			Loc Code	<u>)ty</u>	Loc (Location				•
WA 6			-				6			WA				

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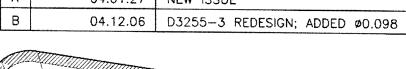
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Resolution:	Disposition:	QA: N/C Closed:	Date:

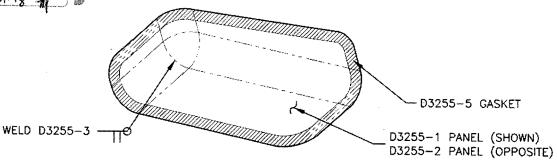
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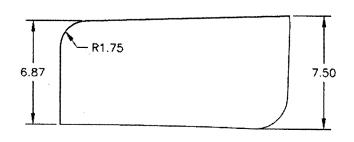
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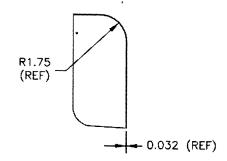


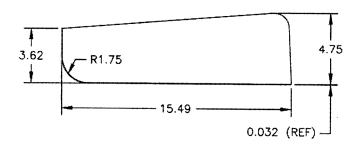




D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)







SHOP CC 114 RETURN : ENGINEER 11 11

UNCONTROLL OPY SUBJECT TO AMINATIMENT

WITHOUT NOTE OF

WORK ORDER NO. 75767 M.C.J

11/11/02

D3255-1 BEND DETAIL D3255-2 OPPOSITE

D3255-041/-042 NOTES:

1) WELD PER DART QSI 004
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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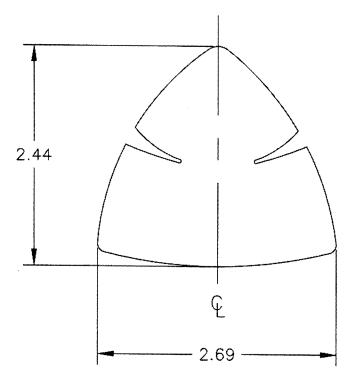
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D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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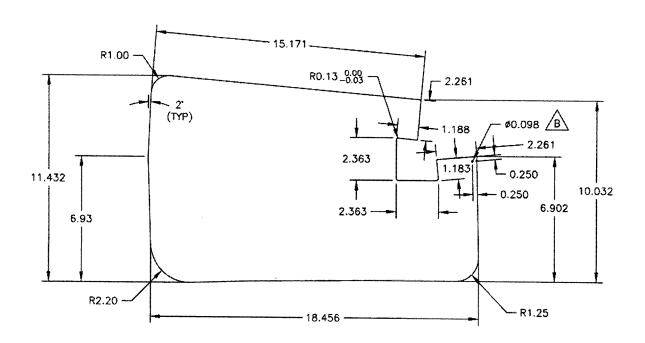
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DATE	STEP	Description of NC		Corrective Action Section	on B	Verific	ation		_
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D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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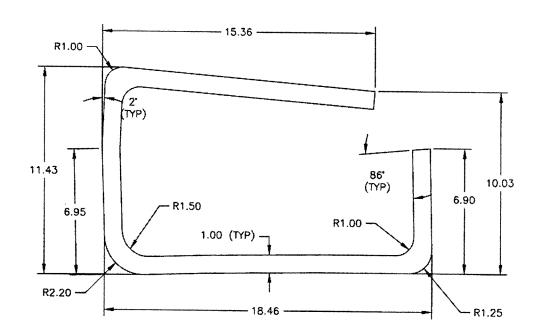
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D3255-5 GASKET

- D3255-5 NOTES:

 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
 P/N SIL/F 36x36x1/16
 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES					
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